

Date: Tuesday, 5/16/2006 10:41:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING
 Job Number : 27151
 Estimate Number : 10336
 P.O. Number : N/A Part Number : D2807
 This Issue : 5/16/2006 S.O. No. : N/A Drawing Number : D2807 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C
 Previous Run : 26646 Material : N/A
 Written By : SEE 1A COMMENT BELOW Due Date : 5/30/2006 Qty: 50 Um: Each
 Checked & Approved By : 06-05-16
 Comment : Est: D 05.06.21 Removed painting; Changed supplier
 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1299

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

CL06/05/19 (50)

2.0 SXF6S6050080S6L115N GAS SPRING



Comment: Qty.: 1:0000 Each(s)/Unit Total: 50.0000 Each(s)

SUPPORT PROP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

10/12/13 50

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-06-14 (50)
 QSY 015

5.0 D28073 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:



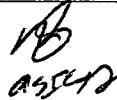
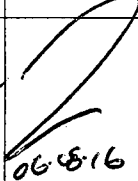
2 D2807-3 Lug Batch: B27563 ~~XXXX~~ B26647 (17)


(83)

SAD 06:07:20

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/03/16	6	2 D2807-3 fit not well. Threads not all the way in.	 Design	removed + replace it Scrap D2807-3	SB 06/03/16	 06-08-16	 05/08/16	 06-08-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/16

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/16/2006 10:41:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 27151

Part Number: D2807

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe. *SAB 06/07/20* *50*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 388*

RB 06/08/16 *50*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/17 *50*

Job Completion



C Loc 108/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

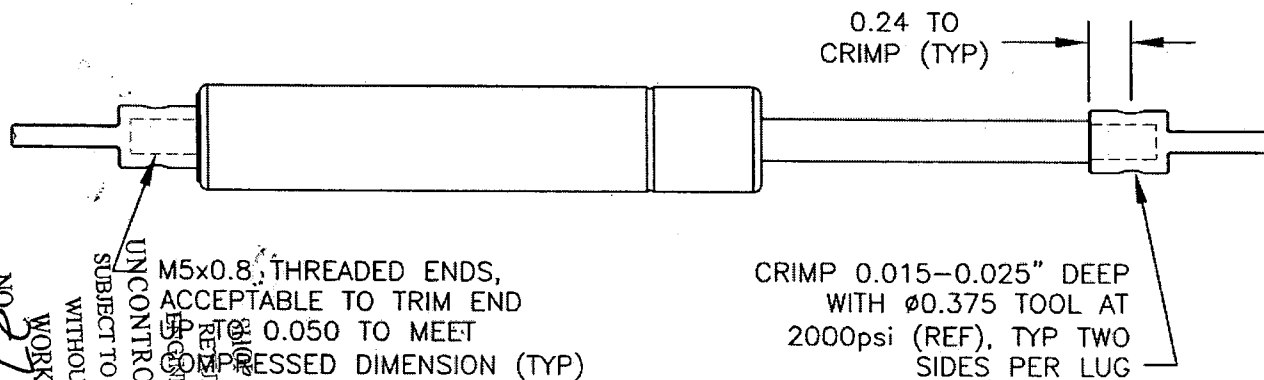
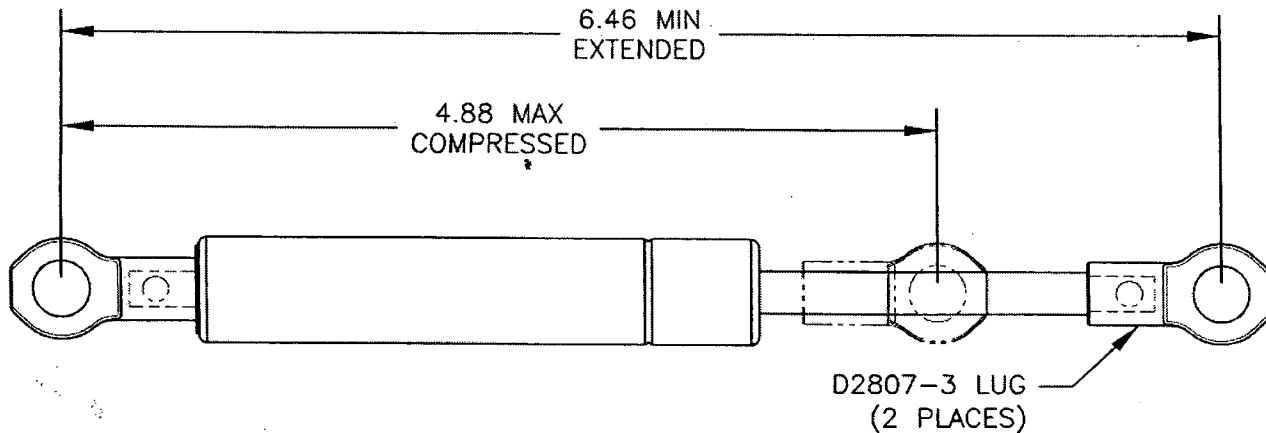
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

RELEASED
05-06-16



WORK ORDER
NO 21157

D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

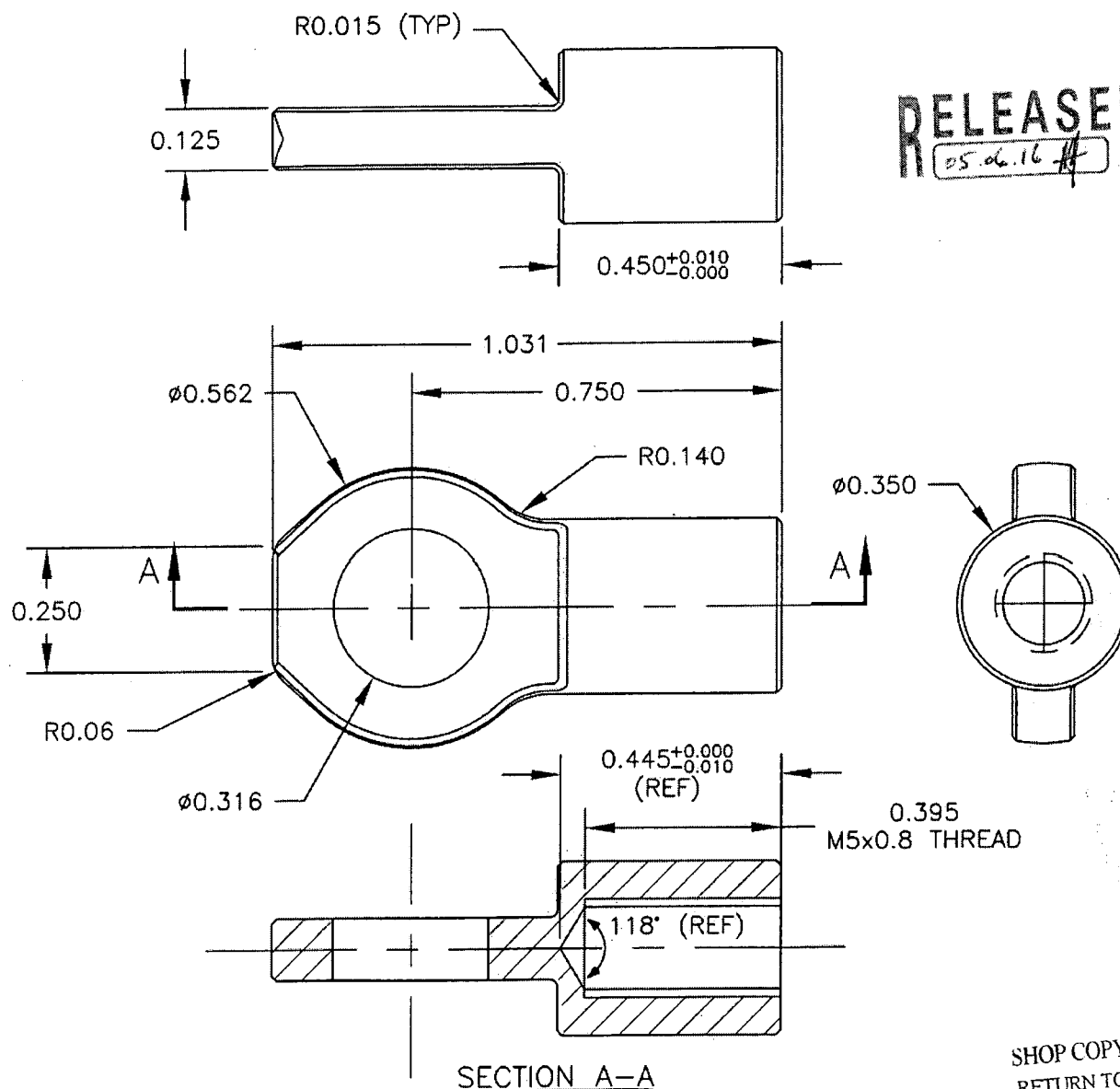
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2807	SHEET 1 OF 2
DATE		TITLE	SCALE
05.05.25		GAS SPRING	1:1
A	00.11.03	NEW ISSUE	
B	05.03.16	ADD FINISH	
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG	

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27151

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DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

DART AEROSPACE LTD
SHIP WITH AE:57522 VIA
FEDEX P-1 OVERNIGHT SVCE
ACCOUNT NO: 15179324-0

DATE
070606

A/C No.
20111

AREA
46

CUSTOMER REF. No.

PO 000001299

V.A.T. REGISTRATION No. GB 738 8577 71

W ORDER

~~NUMBER~~

[illegible]

SPECIAL INSTRUCTIONS		SHIP DATE	CARRIER CODE	WEIGHT	DESPATCH TICKET
		07JUN06			

Cam 001

Main Tel: +44 (0)116 274 3600
Sales Tel: +44 (0)116 274 3622
Accounts Tel: +44 (0)116 274 3616

15 New Star Road, Leicester, LE4 9JD, UK
Main Fax: +44 (0)116 274 3620
E-mail - info.amcl@arvinmeritor.com
Website: www.camloc.com

YOUR ORDER WAS PACKED BY

Certified that the whole of the supplies detailed hereon have been inspected and tested and unless otherwise stated conform in all respects with the contract/purchase order

SIGNED

